

Work Order ID 127340

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127340

Page 1

Item ID: D350-567-113 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Exterior SS Window
 Start Date: 12/09/14 Start Qty: 4.00 ***4*** *Label only* Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-12-18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-567	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo <i>M. 10.</i>	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD350-567-113		CHG003						
110	Packaging	0.00							
110									
Packaging	Memo	0.00							
Packaging	Pick Packing Kit								
	ENSURE DT 8439 TEMPLATE IS INCLUDED								
120	QC4: 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 150120
 DAS 46
 9-89
 JAN 20 2015

4x
 DAS 28
 9-89
 JAN 20 2015

4
 DAS 46
 9-89
 JAN 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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 Item Name: Replacement Exterior SS Window
 Start Date: 12/09/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				4	DAS 46 9-89		DAS 05 0-CC
130	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-567-113								
Packaging	Location: 15-01-20								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(N) 15-1-20

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 127340

127340

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior SS Window

Start Date: 12/09/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 04-08-24 New Issue JLM

IPP Rev:B 08-10-07 as per revD DD verified by:

IPP REV:C

13.10.15 AS PER IIN REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DT8439		Manufactured	No				Each	0.0000	✓	4			
DT8439	DAS								**		DAS		
TEMPLATE	46										28	JAN 20 2015	
D2463	9-89	Manufactured	No			110	f	1,083.000	7.166	31			
D2463									**		DAS		
1/2" Seal (\$Per Foot)											28		
											9-89		
cut(1) at 86" per kit = x4 DAS 46 9-89 DAS 38 9-89													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST409			83					
					115701			83					
					ST638			1000					
					125469			1000		31			
D3290-041		Manufactured	No			110	Each	6.0000		4			
D3290-041									**		DAS		
Replacement Exterior Window For -111											28		
											9-89		
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST434			6					
					108744			4		2			
					120157			2		2			
2600-6		Purchased	No			110	Each	204.0000	12	48			
2600-6									**		DAS		
Camlock Stud											28		
											9-89		
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST569			204					
					M128398			104		48			
					M129790			100					

DQA: _____ Date: _____



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Design									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Work Order ID: 127340

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Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior SS Window

Start Date: 12/09/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

2600-LW

Purchased No

110 Each

187.0000

-12 48

2600-LW

Washer, Camlock Retaining

DAS
46
9-89

Location

Loc Qty

Loc Code

ST570

187

m128429

100

m128818

87

110 Each

263.0000

-12 48

212-12

Purchased No

212-12

Receptacles

DAS
46
9-89

Location

Loc Qty

Loc Code

ST567

263

M128818

175

M129706

88

110 Each

376.0000

-12 84

AN526C832R9

Purchased No

AN526C832R9

Screw

DAS
46
9-89

Location

Loc Qty

Loc Code

ST327

376

M129391

376

110 Each

708.0000

-12 168

NAS1149DN832J

Purchased No

NAS1149DN832J

Washer

DAS
46
9-89

Location

Loc Qty

Loc Code

MF4

185

M129541

185

ST270

523

124555

143

M128429

296

M129499

84

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Shop Packet Print

Page 2

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Work Order ID: 127340

Parent Item: D350-567-113

Parent Item Name: Replacement Exterior SS Window

127340

D350-567-113

Start Date: 12/09/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

MS21042L08

Purchased

No

110

Each

1,295.000

21

84

MS21042L08

Nut

DAS
46
9-89

**

DAS
28
9-89

JAN 20 2015

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST304

1194

123900

16

m128401

578

m130325

600

MS20426AD3-5

Purchased

No

110

Each

5,901.000

24

96

MS20426AD3-5

Rivet

DAS
46
9-89

**

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

4325

4533

4325

ST313

1576

4444

1576

FG-778150-550-ROL

Purchased

No

110

sf

1,398.000

18

72

*FG-778150-550-ROL *

7781 9oz Glass 50x125yd

DAS
46
9-89

**

DAS
28
9-89

Location

Loc Qty

Loc Code

CA2

1370

M127701

1370

st417

28

M127701

28

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Shop Packet Print

Page 3

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